

Date: Wednesday, 2/21/2007 10:59:02 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR INSTALLATION
Job Number	: 30786		
Estimate Number	: 12747		
P.O. Number	: N/A	Part Number	: EA2046927
This Issue	: 2/21/2007 S.O. No. : N/A	Drawing Number	: D20446901 REV 1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: 1
Previous Run	: N/A	Material	: N/A
Written By	: <u>ml 07-02-21</u>	Due Date	: 2/28/2007
Checked & Approved By	: _____	Qty:	2 Um: Each
Comment	: Est Rev:A New Issue 07-02-21 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NS063	4130 Sheet .063
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Comment: Qty.: 0.0756 sf(s)/Unit Total : 0.1512 sf(s)

4130 Sheet .063

Batch: ml 07 02 22

(2)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2046901

Dwg Rev: 1Prog Rev: 1ml 07 02 22

(2)

2-Deburr if necessary

ml 07 02 22

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07 02 22

(2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 07-02-22

(2)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ml 07/02/22 (2)

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Process Sheet

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Drawing Name: VERTICAL REFERENCE DOOR INSTALLATION

Job Number: 30786

Part Number: EA2046927

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

07/02/23

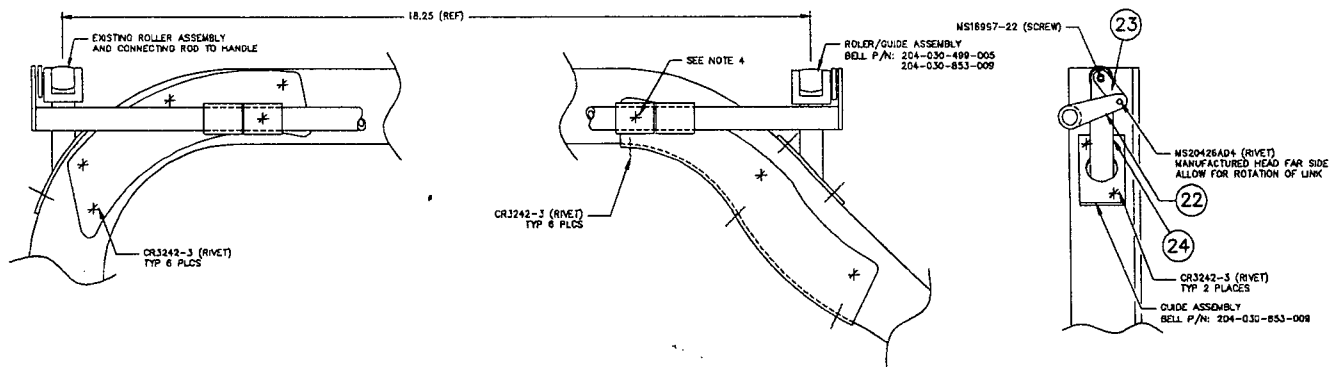
Job Completion



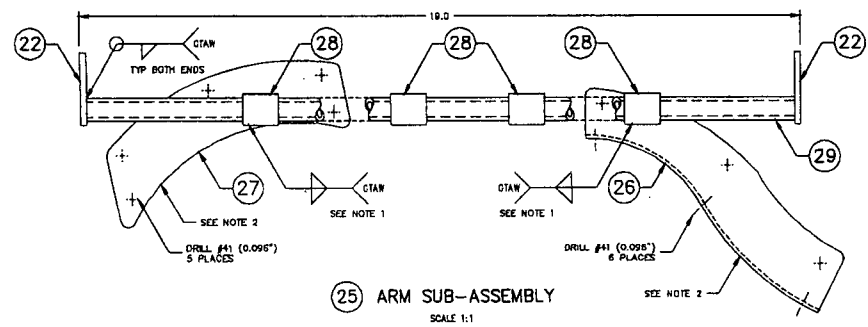
U 07.02.23

24 4/30 158' F.

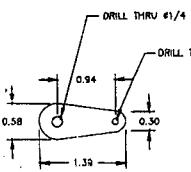
NOTICE			
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	DW	15 AUG 2000



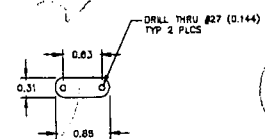
UPPER DOOR LATCH ASSEMBLY
SCALE 1:1



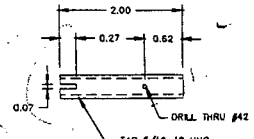
ARM SUB-ASSEMBLY
SCALE 1:1



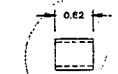
22 LUG
SCALE 1:1



23 LINK
SCALE 1:1



24 ROD
SCALE 1:1



28 ARM GUIDE
SCALE 1:1

- NOTES FOR SHEET 3.
1. WELDING OF 4130 STEEL ALLOY TO BE COMPLETED BY GTAW METHOD TO AMS2655C. WELDING ROD SHALL CONFORM TO AMS 6451A OR LATER REVISION.
 2. HEAT AND FORM DOOR PLATES (ITEM 26 & ITEM 27) TO SHAPE OF DOOR JAM. PLOT HOLE LOCATIONS ARE APPROXIMATE. MAINTAIN 20 EDGE DISTANCE.
 3. THOROUGHLY DEGRASS, PRIME, AND PAINT ALL PIECES AFTER ASSEMBLY.
 4. OUTER PAIR OF ARM GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARM GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THEN FASTENED TO ARM WITH CR3242-3 RIVETS AFTER ARM ALIGNMENT.

QTY.	DASH NO.	DESCRIPTION	PART NO.	MATERIAL	MATERIAL SPEC.	STOCK SIZE
1	29	ARM	EA20469-29	4130 STEEL	MIL-T-8736	63/8 O.D. x 0.093 WALL
4	28	ARM GUIDE	EA20469-28	4130 STEEL	MIL-T-8736	1 1/2 O.D. x 0.063 WALL
1	27	DOOR PLATE	EA20469-27	MILD STEEL		0.063" SHEET
1	26	DOOR PLATE	EA20469-26	MILD STEEL		0.063" SHEET
1	25	ARM SUB-ASSEMBLY	EA20469-25			
1	24	ROD	EA20469-24	4130 STEEL	MIL-T-8736	63/8 O.D. x 0.093 WALL
2	23	LINK	EA20469-23	4130 STEEL	MIL-S-18729	0.063" SHEET
2	22	LUG	EA20469-22	4130 STEEL	MIL-S-18729	0.063" SHEET
1	21	DOOR COVER PANEL	EA21469-21			
1	20	FLIGHT MANUAL SUPPLEMENT 214B, 214B-1	EA21469-20			
1	20	FLIGHT MANUAL SUPPLEMENT 212, 412	EA21269-20			
1	20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20569-20			
1	20	FLIGHT MANUAL SUPPLEMENT 204B	EA20469-20			
1	19	CABLE SERVICE INSTRUCTION	EA20469-19			
1	18	DOOR INNER SKIN	EA20469-18			
1	17	ANGLE	EA20469-17			
1	16	ARM REST ASSEMBLY	EA20469-16			
1	15	INSTRUMENT PANEL	EA20469-15			
1	14	WINDOW RETAINER	EA20469-14			
1	13	INSTRUMENT WINDOW	EA20469-13			
1	12	FORWARD RIB	EA20469-12			
1	11	ANGLE	EA20469-11			
1	10	REARWARD RIB	EA20469-10			
1	9	ANGLE	EA20469-09			
1	8	PLACARD - INSTRUMENT PANEL	EA20469-08			
1	7	ANGLE	EA20469-07			
1	6	ALUMINUM STRIP	EA20469-06			
1	5	RUBBER STRIP	EA20469-05			
1	4	DOOR LATCH ASSEMBLY	EA20469-04			
1	3	PERICLASS BUBBLE WINDOW	EA20469-03			
2	2	INSTALLATION - DOOR MOUNTED INSTRUMENTS				
1	1	INSTALLATION - BUBBLE WINDOW				

BASIC CODE		DASH NO. FOR DIA N=1/8" HEAD NEAR SIDE F=1/8" HEAD FAR SIDE		APPROVALS		DATE	
D-COUPLE DOT = # OF SHEETS TO BE DUMPED C=COUNTERSINK		DASH NO. FOR LENGTH		E. BURTON		25 AUG 1991	
BASIC CODES: B1 = MS20470AD B2 = MS20470AD B3 = MS20470AD B4 = MS20470AD B5 = MS20470AD				STRESS			
* INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ±0.010 ANGLES ±1/2° X.XX ±0.03 X.X ±0.1			
SCALE AS NOTED				Dwg. SIZE		REV.	
SHEET 3 OF 3				A1		D2046901 1	

AERO DESIGN LTD.
CONVERTING ENGINEERING, TRANSPORT CANADA APPROVED, 1991
EAGLE COPTERS LTD.
823 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2C 2P9
BELL 204, 205, 212 & 214
VERTICAL REFERENCE DOOR
INSTALLATION

